

Date: Wednesday, 11/22/2006 1:39:34 PM
 User: Kim Johnston

Process Sheet

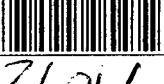
Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29647B
 Estimate Number : 10462
 P.O. Number : N/A
 This Issue : 11/22/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 29236B
 Written By : KJ 06/11/22
 Checked & Approved By :
 Comment : Est:A 04.04.19 New issue KJ/JLM

Drawing Name : SUPPORT
 Part Number : D32782
 Drawing Number : D3278 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 11/29/2006
 Qty: 100 Um: Each
 Comment: Split 100 20

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0" 
		Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Batch: <u>M19295</u> <i>mf 07/01/08</i> 
2.0	SHEAR SAW	SHEAR 
		Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long <i>mf 07/01/08</i> 
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2 <i>JF 07/01/10</i> 
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JF 07/01/10</i> 
5.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>mf 07/01/10</i> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/11
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 29647B

Part Number: D32782

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING	HAND FINISHING RESOURCE #1 07-01-10 (20)
7.0	POWDER COATING	POWDER COATING M7102391 (20x)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION ml07/01/11
9.0	PACKAGING 1	PACKAGING RESOURCE #1 ml07/01/11
10.0	QC21	FINAL INSPECTION/W/O RELEASE ml07/01/11

Job Completion



U 82-01-11

DART AEROSPACE LTD	Work Order:	29647B
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.100"	✓			
0.359	+/-0.005	.359"	✓			
0.615	+/-0.010	.615"	✓			
0.250	+/-0.010	.249"	✓			
1.480	+/-0.005	1.485"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	.120"	✓			
2.439	+/-0.010	2.439"	✓			
1.980	+/-0.010	1.982"	✓			
R0.130	+/-0.010	R0.130"	✓			
Ø0.257	+0.005/-0.000	Ø.261"	✓			
R0.375	+/-0.010	R.375"	✓			
0.875	+/-0.010	.877"	✓			
0.500	+/-0.010	.500"	✗			
R0.400	+/-0.010	R0.400"	✓			
1.720	+/-0.010	1.722"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.125	+/-0.010	.128"	✓			

Measured by: <u>J.F.</u>	Audited by: <u>S.</u>	Prototype Approval: N/A
Date: <u>07/01/09</u>	Date: <u>07/01/09</u>	Date: N/A

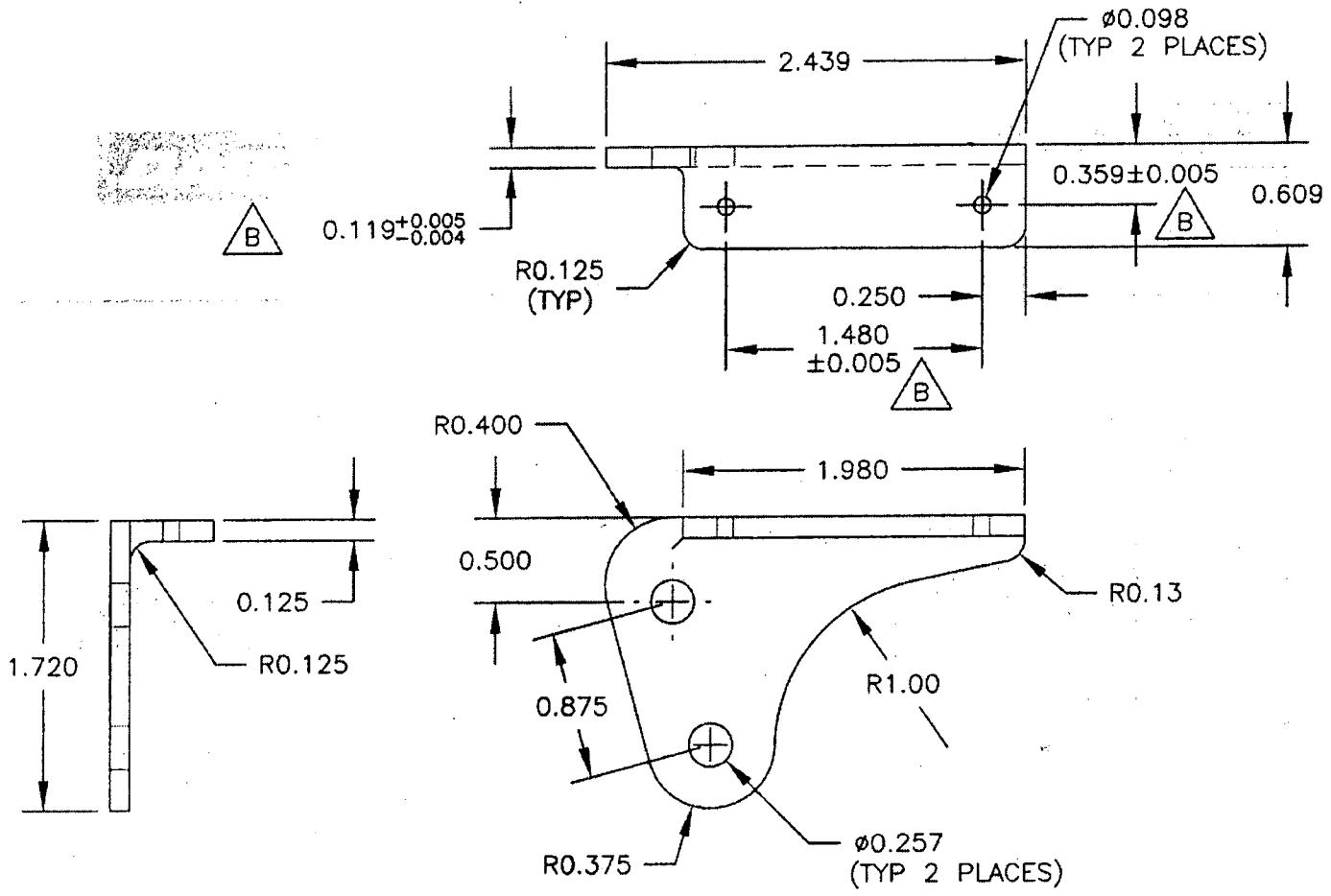
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3278
DATE 05.03.31		REV. B SHEET 2 OF 3 TITLE SCALE 1:1 SUPPORT ASSEMBLY

RELEASED

05.04.04 #

D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RECORDED COPY
REVIEWED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29647B